

Work Order ID 65771

Tuesday, January 25, 2011 10:42:40 AM



Page 1

Item ID: D206-781-151KIV

Accept



Setup Start



Revision ID:

Item Name: Vertical Tunnel-Ivory

Stop



Start Date: 1/25/2011 Start Qty: 1.00

Required Date: 2/7/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-01-25 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D407-781

D

0.00

100



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-781-151KIV
CHG 001

0.00

Sublet

HJ for CL 11-02-07 Pto →

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

Cap 11 (2)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

Sublet

(2)

W/O: 65771		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/02/15	#110	Perm. Change ADD amount under Qty per kit column and ADD Partin number.	SH	11/02/15			S Muelu

Part No: D206-781-151 KIV PAR #: _____ Fault Category: Prod-Eng-Correl NCR: Yes No DQA: 1 Date: 11/02/15
 Resolution: documented & revised Disposition: _____ QA: N/C Closed: 1 Date: 11/02/15

NCR: 65771		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/15	#110	Found that w/o pick list is missing ALS4-632-130 QH x 6 Per kit		- ADD ALS4-632-130 B* <u>110452</u> QH x 6 per kit to kit	SH 11/2/15	S 11/2/15		S Muelu
		Per w/o + Bom not currently update to ITN instruction parts list R.C: LOA-	11/02/14	- correctly update w/o + Bom. ADD copy of updates Bom for reference.	SH 11/02/15	11/07/15 see attached	11/02/14	S Muelu

NOTE: Date & initial all entries

Work Order ID 65771

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Item ID: D206-781-151KIV

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel-Ivory

Start Date: 1/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-781-151KIV

Location: B
PPP rev

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF

11-02-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 65771

Parent Item: D206-781-151KIV

Parent Item Name: Vertical Tunnel-Ivory

Start Date: 1/25/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-632-80

Purchased

No

Each

202.0000

Kit

8

Insert

Location

Loc Qty

Loc Code

ST282

202

112495

200

17841

2

D3800-1-100 -800

12 per kit

Manufactured

No

f

149.9874

Hook and Loop Strip (1" Soft)

Location

Loc Qty

Loc Code

ST084

89.649

64930

89.649

ST088

60.3384

52694

5.8304

55761

39.167

62911

15.341

D3800-3-100 -800

12 per kit

Manufactured

No

f

221.4610

Hook and Loop Strip (1" Hard)

Location

Loc Qty

Loc Code

ST084

99.14

64931

99.14

ST089

122.321

50912

3

52695

7.86

55762

35.29

60042

50.001

63009

26.17

Cut qty +2 per kit
@ 80.0% → measure
8uloz/1

Cut 2 per kit
@ 80.0% → measure
7.8uloz/1

112495

2.326

64930

2.326

64931

EC

EC

64931 64931 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 65771

Parent Item: D206-781-151KIV

Parent Item Name: Vertical Tunnel-Ivory



Start Date: 1/25/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

D3822-1KIV Manufactured No

Each 0.0000



Vertical Tunnel, LH-Ivory

D3822-2KIV Manufactured No

Each 0.0000



Vertical Tunnel, RH-Ivory

D3822-3KIV Manufactured No

Each 0.0000



Vertical Tunnel, Aft Center-Ivory

D3822-5KIV Manufactured No

Each 3.0000



Vertical Tunnel, Top-Ivory

Location

Loc Qty

Loc Code

ST159A

3

48590D

3

D3822-7KIV Manufactured No

Each 0.0000



Vertical Tunnel, Lower-Ivory

NAS388-6-12P Purchased No

Each 118.0000



Screw

Location

Loc Qty

Loc Code

ST278

118

111310

1

115815

37

116523

80

8/1



2
65774



2
65775



2
65776



2



48590



1
65777



28

6/4/11

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 65771

Parent Item: D206-781-151KIV

Parent Item Name: Vertical Tunnel-Ivory

Start Date: 1/25/2011

Required Date: 2/7/2011

Start Qty: 1.00 2

Required Qty: 1.00

NAS388-6-8P

Purchased

No

Each

117.0000



Screw



Location

Loc Qty

Loc Code

ST278

117

113470

17

116416

100

NAS391B6P

Purchased

No

Each

155.0000



Washer



Location

Loc Qty

Loc Code

ST278

155

112616

5

115589

50

116416

100

1116416

36

1115889 24x

1116416 12x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.2 D206-781-141/-143/-151/-161/-171/-173/-191/-193 KITS

Qty -141	Qty -143	Qty -151	Qty -161	Qty -171	Qty -173	Qty -191	Qty -193	Part Number	Description
X								D206-781-141	CREW CABIN OVERHEAD W/O ROTOR BRAKE KIT
	X							D206-781-143	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
		X						D206-781-151	VERTICAL TUNNEL KIT
			X					D206-781-161	REAR OVERHEAD KIT
				X				D206-781-171	HAT BIN KIT
		1			X			D206-781-173	HAT BIN KIT, LITTER KIT COMPATIBLE
						X		D206-781-191	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
							X	D206-781-193	ROTOR BRAKE PANEL KIT
1								D3821-1	PANEL - W/O ROTOR BRAKE
	1							D3821-3	PANEL - W/ ROTOR BRAKE
4	4							NAS388-6-8P	SCREW
4	4							NAS391B6P	WASHER
		1						D3822-1	VERTICAL TUNNEL, LH
		1						D3822-2	VERTICAL TUNNEL, RH
		1						D3822-3	VERTICAL TUNNEL, AFT CENTER
		1						D3822-5	VERTICAL TUNNEL, TOP
		1						D3822-7	VERTICAL TUNNEL, LOWER
		2						D3800-1-100-800	LOOP STRIP
		2						D3800-3-100-800	HOOK STRIP
		4						NAS388-6-8P	SCREW
		14						NAS388-6-12P	SCREW
		18						NAS391B6P	WASHER
		4						ALS4-632-80	INSERT
		8						ALS4-632-130	INSERT
			1					D3823-1	REAR OVERHEAD, LH
			1					D3823-2	REAR OVERHEAD, RH
			1					D3823-3	REAR OVERHEAD, CENTER
			10					AN525-10R24	SCREW
			10					NAS43DD3-68	SPACER
				1				D3824-1	HAT BIN
					1			D3824-3	HAT BIN
				6	6			D3851-1	DOUBLER
				4	4			AN525-10R10	SCREW
						1		D4077-1	OVERHEAD PANEL, LH
						1		D4077-2	OVERHEAD PANEL, RH
							1	D4118-1	ROTOR BRAKE PANEL
						1		D4119-1	PANEL
						6		NAS388-6-8P	SCREW
							4	NAS388-6-12P	SCREW
						6		NAS391B6P	WASHER
							4	MS21059L06	NUTPLATE
							8	MS20426AD3-3	RIVET

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Revision: A

Date: 10.10.28

D206-781-151KIV

Status	Item ID	Rev	Name	Start Date	Quantity	UOM	Op Date	Sec	rap	ap	Qua	mm	end	N	C	IL	CX	ISort	me	Off	sel	Ty	1	Per	Och	to	lore	Ce	Last	Idd	Dat
✓	ALS4632-130		insert	2/15/2011	8.0...	Ea			0	0.0...								0	0	M...								2/1...	2/...		
✓	ALS4-632-80		Insert	6/24/2009	4.0...	Ea			0	0.0...								0	0	M...								12/...	12...		
✓	D3800-1-100		Hook and Loop Strip...	12/5/2009	1.3...	f			0	0.0...								0	0	M...								12/...	12...		
✓	D3800-3-100		Hook and Loop Strip...	12/5/2009	1.3...	f			0	0.0...								0	0	M...								12/...	12...		
✓	D3822-1KIV		Vertical Tunnel, LH-I...	12/5/2009	1.0...	Ea			0	0.0...								0	0	M...								12/...	12...		
✓	D3822-2KIV		Vertical Tunnel, RH-I...	12/5/2009	1.0...	Ea			0	0.0...								0	0	M...								12/...	12...		
✓	D3822-3KIV		Vertical Tunnel, Aft...	12/5/2009	1.0...	Ea			0	0.0...								0	0	M...								12/...	12...		
✓	D3822-5KIV		Vertical Tunnel, Top...	12/5/2009	1.0...	Ea			0	0.0...								0	0	M...								12/...	12...		
✓	D3822-7KIV		Vertical Tunnel, Low...	12/5/2009	1.0...	Ea			0	0.0...								0	0	M...								12/...	12...		
✓	NAS388-6-12P		Screw	6/24/2009	14....	Ea			0	0.0...								0	0	M...								12/...	12...		
✓	NAS388-6-8P		Screw	6/24/2009	4.0...	Ea			0	0.0...								0	0	M...								12/...	12...		
✓	NAS391B6P		Washer	6/24/2009	18....	Ea			0	0.0...								0	0	M...								12/...	12...		